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D5404-1**Job Sheet 203096**

Part No: D5404-1

Job Qty: 8 pcs

DAS

21

3-85

Part Name: Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/19

Job Tracking No:

Due Date: 12/16/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5404 REV. B SHEETS 3,4 IPP REV:A 16.03.23 NEW ISSUE DD VERF:JLM IPP REV:B 19.05.16 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs		12/16/19	0.17	2.00	Waterjet - Flow		2019/11/26
110	QC 2	8 pcs		12/16/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		2019/11/26
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	8 pcs	12/16/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - Brake NC - B4B	8 pcs	12/16/19	0.25 0.53	Small Fab - Brake - 1 - B4B	DAS 40 NOV 30 2019 9-89
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	8 pcs	12/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Packaging 3-1 - Stock - B4B	8 pcs	12/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	

				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	EL
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	8 pcs	12/16/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	200
Part Op 100 - 1-Cut D5404-1 as per Dwg Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Form D5404-1 as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Identify as per dwg & Stock Location: <u>W/Map-2</u>) 160 - (QC21- Final Inspection - Work Order Release)					DEC 09 2019
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S18GA	304/316 .050 Sheet	33.2000 sf (4.15 ea)	100-Waterjet - Flow - 1		S232322
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M304S18GA	33	88	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 203096
Description: Plate		Part Number:
Inspection Dwg: DSHM-1	Rev: C	Page 1 of 1

INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC						
Ø.625	-0.001 +.005	Ø.624			VDC-02	
Ø.19	-0.001 +.005	Ø.193			Tape	
.650	+/- .010	.649				
.516	+/- .010	.514				
.15	+/- .030	.153				
.50	+/- .030	.506				
.13	+/- .030	.129				
.50	+/- .030	.506				
4.57	+/- .030	4.575				
6.46	+/- .030	6.46				
1.80	+/- .030	1.80				
.55	+/- .030	.55				
21.62	+/- .030	21.62				
57.62	+/- .030	57.62				
62.87	+/- .030	62.87				
Manual Milling						
63.68	+/- .030	63.68				
64.86	+/- .030	64.86				
65.68	+/- .030	65.68				
91.18	+/- .030	91.18				
91.68	+/- .030	91.68				
1.00	+/- .030	1.00				
4.80	+/- .030	4.80				

Measured by: DC	Audited by: DAS 40	Preliminary Approval:
Date: 19/11/2019	Date: NOV 30 2019	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation		Disposition		Completed By _____	
				Lead hand / Supervisor _____	
				QC / QA Coordinator _____	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Container No: S234836



Part: D5404-1

Job No: 203096

Serial No/Batch: S234836

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

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